

(B)

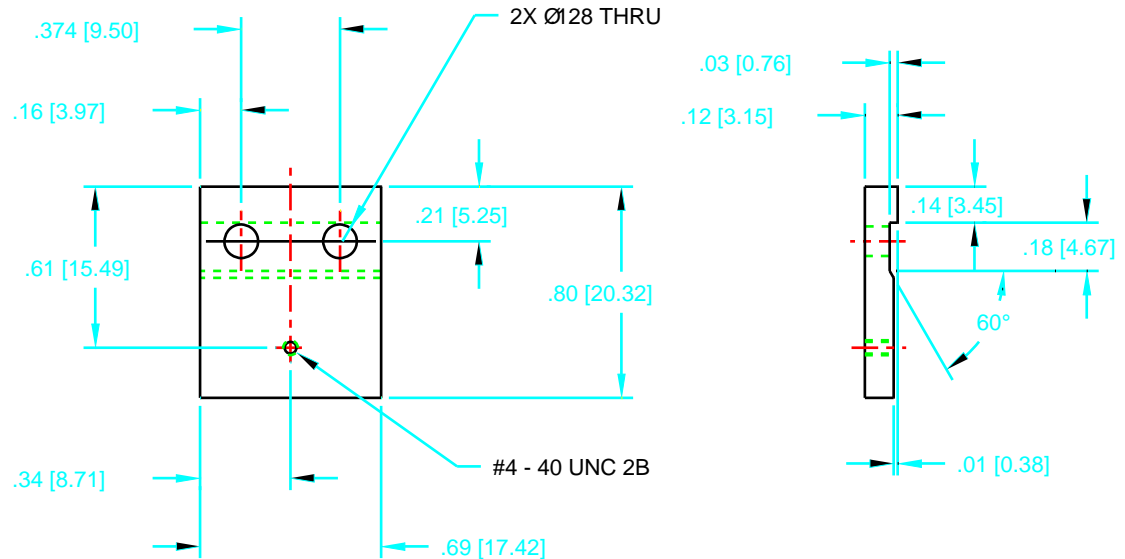
PLOT SCALE: 1=1

DWG. SCALE: 1

A2413100

NOTES:

1. THIS IS A ULTRA- HIGH VACUUM COMPONENT (UHV)
2. WHEN MACHINING VACUUM PARTS, USE OF SILICONE AND SULPHUR-BASED CUTTING FLUIDS IS PROHIBITED. USE ONE OF THE FOLLOWING:
  - A) CIMCOOL 5 STAR 49
  - B) TRIM SOL
3. ALL SURFACES MUST BE MACHINED FOR CLEAN UP
4. FINISHING: WHEN MACHINING VACUUM PARTS USE OF ABRASIVE PAPER OR SANDING DISCS, BUFFING OR POLISHING COMPOUNDS, OR RESIN-BONDED GRINDING WHEELS IS PROHIBITED
5. CLEANING: THE COMPONENT MUST BE CLEANED SUCH THAT A UHV PRESSURE OF  $1 \times 10^{-9}$  TORR CAN BE ACHIEVED
6. HANDLING: THE COMPONENTS SHALL BE HANDLED WITH WHITE SILK GLOVES AND WRAPPED WITH ALUMINUM FOIL TYPE DRY ANNEAL AND UNDER CLEAN ROOM CONDITIONS
7. BREAK ALL SHARP CORNERS 0.03
8. DIMENSIONS IN [ ] ARE MILLIMETERS AND FOR REF. ONLY



SCALE 2X

SYM	CHANGE DESCRIPTION	BY	CHKD	DATE
REVISIONS				

ITEM	DWG/PART NUMBER	NOMENCLATURE OR DESCRIPTION	MATERIAL / SPEC	QTY
PARTS LIST				
UNLESS OTHERWISE SPECIFIED: ALL DIMENSIONS ARE IN INCHES		LOG NUMBER <b>A2413100</b>	THIS DRAWING IS THE PROPERTY OF <b>ARGONNE NATIONAL LABORATORY</b>	
TOLERANCES		TITLE <b>ADVANCED PHOTON SOURCE</b>		
DECIMALS		ANGULAR	L2-90 "PINK BEAM"	
.X - .03 [ .7620]		- .25	SLIT/BPM DIAMOND	
.XX - .01 [0.25]			SENSOR CLAMP	
.XXX - .005 [0.127]				
SURFACE ROUGHNESS		63		
REMOVE ALL BURRS AND BREAK SHARP EDGES .03 MAX.				
SURFACE TEXTURE TO BE IN ACCORDANCE WITH LATEST ANSI B46.1				
DIMENSIONING & TOLERANCING IN ACCORDANCE WITH LATEST ANSI Y14.5				
DO NOT SCALE DRAWING				
DRAWN BY <b>MUSCIA</b>		DATE <b>3/12/96</b>	CHIEF DESIGN ENGINEER <b>D. SHU</b>	DATE <b>6/23/96</b>
CHECKED BY <b>D. SHU</b>		DATE <b>6/23/96</b>	GP LEADER <b>T.M. KUZAY</b>	DATE <b>6/26/96</b>
DESIGNER <b>SHU/MUSCIA</b>		DATE <b>3/12/96</b>	PROJECT MGR.	
RESPONSIBLE ENGINEER <b>D. SHU</b>		DATE <b>6/23/96</b>	APPROVED/RELEASED	
MATERIAL <b>MACHINABLE CERAMIC</b>		SCALE <b>1:1</b>	SIZE <b>B</b>	DRAWING NUMBER <b>P4105091502-910209-00</b>
		SHEET <b>1 of 1</b>		